

# Work Order ID 53514

November 6, 2009 4:10:17 PM



Page 1

Item ID: D3480-043

Accept



Setup Start



Revision ID: C

Stop



Item Name: Eyeball Adapter

Start Date: 06/11/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 17/11/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: *PL*

Date: *07-11-9*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3480	Rev C								
100		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Spot weld as per dwg D3480								
									<i>7m-d w/w/2a</i>
110		0.00							
	QC11- Inspect spot weld per QSI004								
QC	Memo	0.00							
Quality Control									<i>SB 10/10/01</i>
									<i>(2)</i>
120		0.00							
	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									<i>SB 10/10/01</i>
									<i>(2)</i>

*(2x)*

*7m-d w/w/2a*

*SB 10/10/01*

*(2)*

*SB 10/10/01*

*(2)*

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November 6, 2009 4:10:17 PM



Page 2

Item ID: D3480-043

Accept



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Stop



Item Name: Eyeball Adapter

Start Date: 06/11/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 17/11/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>062</u>	0.00							
	Packaging								
	Memo	0.00							
	Packaging								
140	QC21- Final Inspection - Work Order Release	0.00							
	QC								
	Memo	0.00							
	Quality Control								

10/11/01 (2)

10/11/01 CL

# Picklist Print

November 6, 2009 4:10:26 PM

Page 1

Work Order ID: 53514

Parent Item: D3480-043RevC

Parent Item Name: Eyeball Adapter

Comments:

Start Date: 06/11/2009

Required Date: 17/11/2009

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3480-1RevC

Manufactured

No

100

Each

9.0000

2.0000



Flange

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

9

28809

1

46990

8

NAS1031C3W

Purchased

No

100

Each

87.0000

8.0000



Nutplate

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

87

106574

15

107139

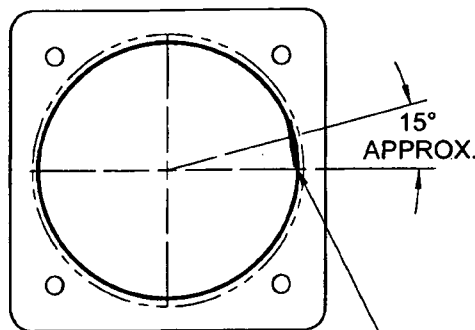
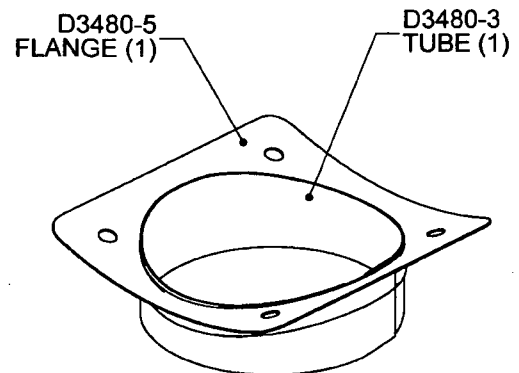
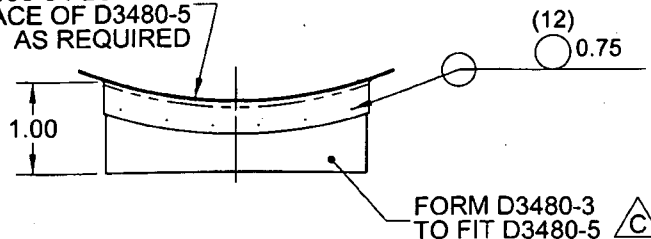
72

1 5/10/04/22

7 5/14/04/22

**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3480</b>	REV. C SHEET 1 OF 6
DATE <b>08.12.19</b>		TITLE <b>EYEBALL ADAPTER</b>	SCALE 1:2
A	06.02.06	NEW ISSUE	
B	06.08.29	D3480-3 0.50 was 0.40/D3480-3F 8.930 was 9.330	
C	08.12.19	D3480-3 PICTORIAL CHG PER D3480-3F (SHT 1 & 4); ADD/REV TOL (SHT 3-5); ADD MFG NOTE (SHT 4); MATL SPEC WAS MIL-S-5019	

**RELEASE**  
*09/01/30 MP*ALIGN WELD  
SEAM OF D3480-3  
AS SHOWNSPOT WELD PARTS.  
TRIM D3480-3 FLUSH TO  
SURFACE OF D3480-5  
AS REQUIREDSHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *53314**MP 09-11-9***D3480-041 EYEBALL INLET ADAPTER****NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3480-041 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3480-041	EYEBALL INLET ADAPTER
1	D3480-3	TUBE
1	D3480-5	FLANGE

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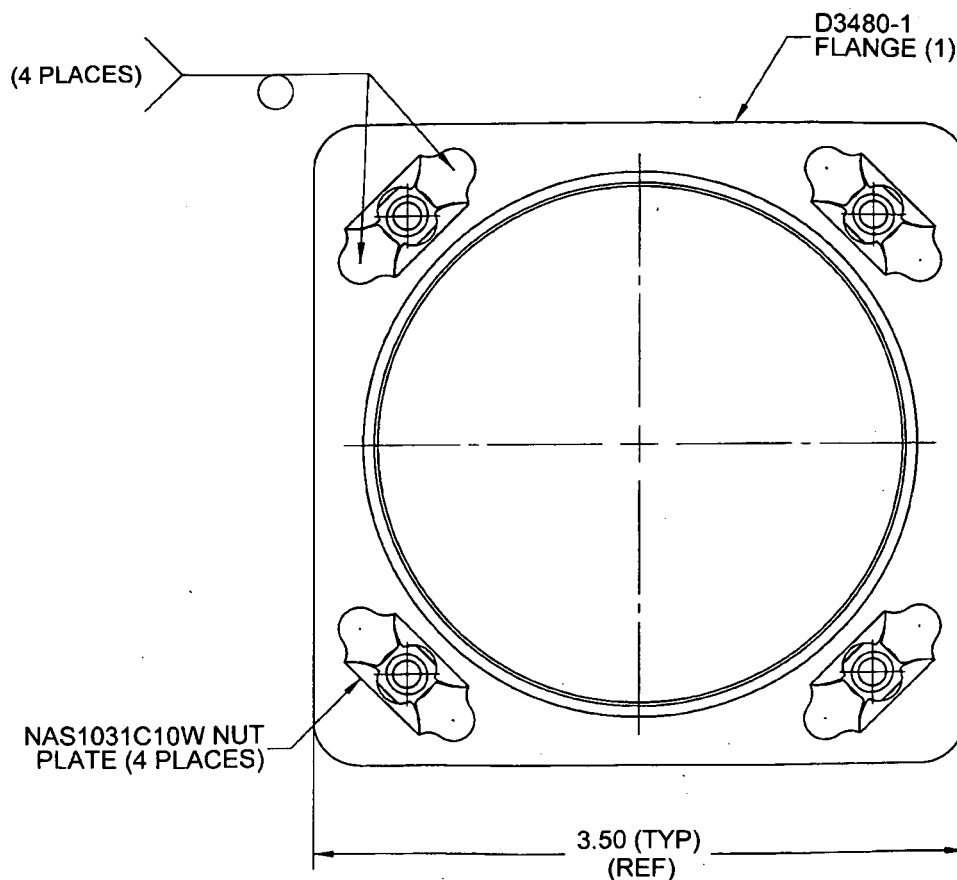
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DATE 08.12.19	TITLE EYEBALL ADAPTER		SCALE 1:1

RELEASE  
9/10/32 MBW

w/o 53514



### D3480-043 EYEBALL ADAPTER

#### NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3480-043 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

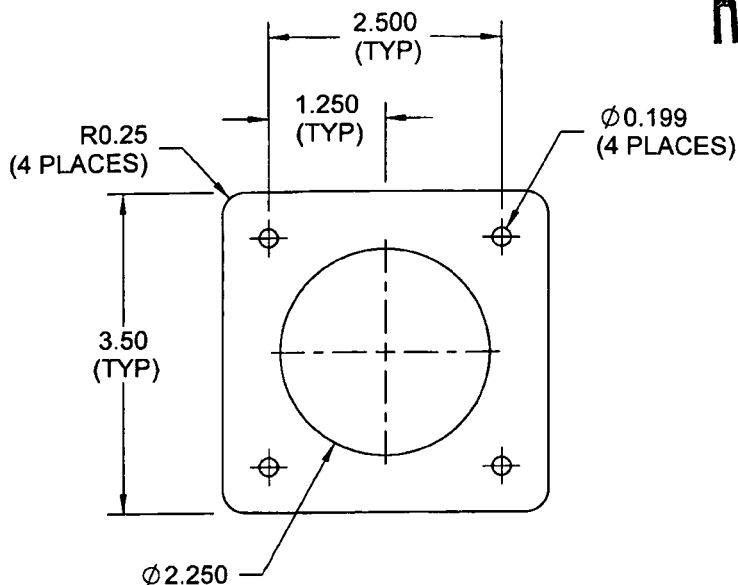
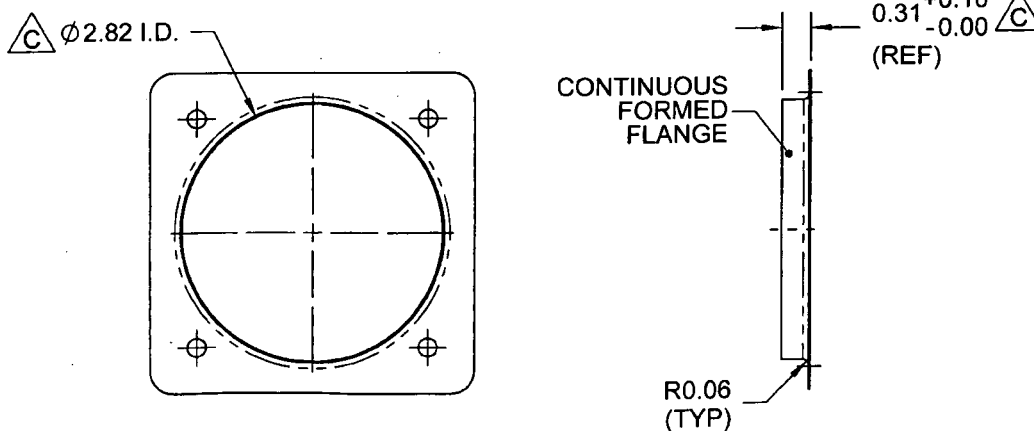
QTY -043	P/N	DESCRIPTION
X	D3480-043	EYEBALL ADAPTER
1	D3480-1	FLANGE
4	NAS1031C3W	NUTPLATE

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DATE 08.12.19		TITLE EYEBALL ADAPTER	SCALE 1:2

**RELEASED**  
*9/6/30 MP***D3480-1F FLAT PATTERN****D3480-1 FLANGE**  
**(MAKE FROM D3480-1F)****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH  $\triangle C$   
OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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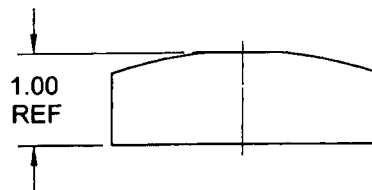
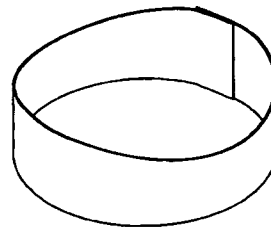
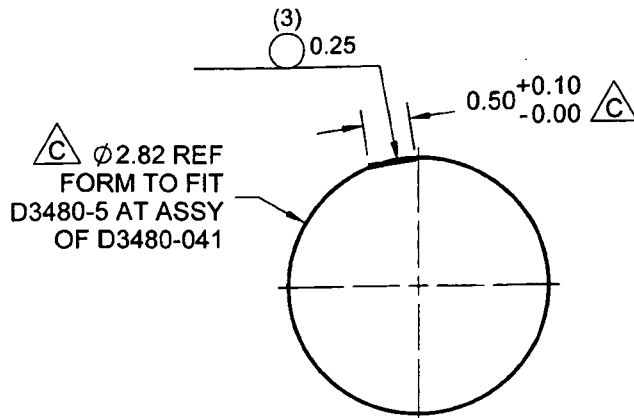
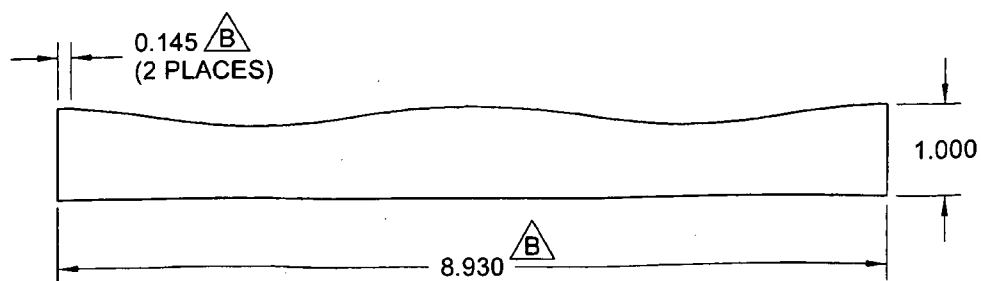
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DATE 08.12.19		TITLE EYEBALL ADAPTER	SCALE 1:2

**RELEASE**  
09/01/30 MD

w/o 53514

**D3480-3 TUBE****D3480-3F TUBE FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH  $\Delta C$   
OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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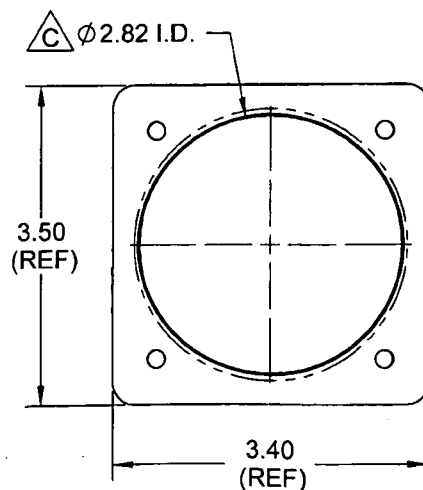
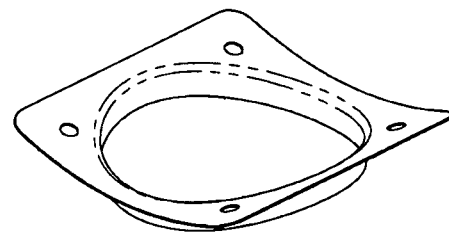
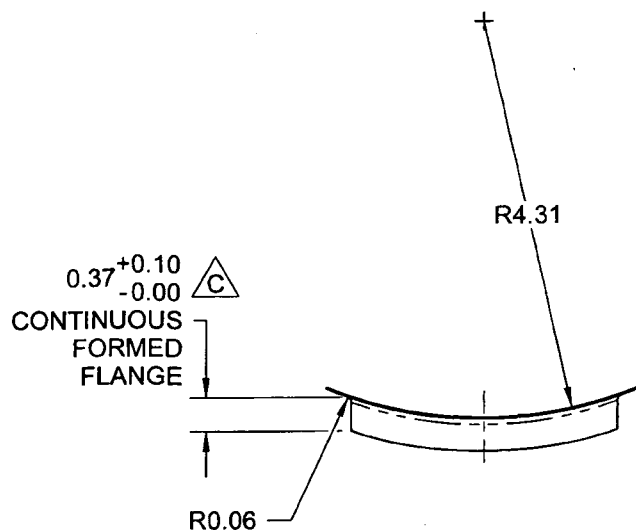
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DATE 08.12.19		TITLE EYEBALL ADAPTER	SCALE 1:2

RELEASED  
09/01/30 NW

W/O 53514



### D3480-5 EYEBALL ADAPTER FLANGE

#### NOTES:

- 1) MATERIAL: MAKE FROM D3480-1F
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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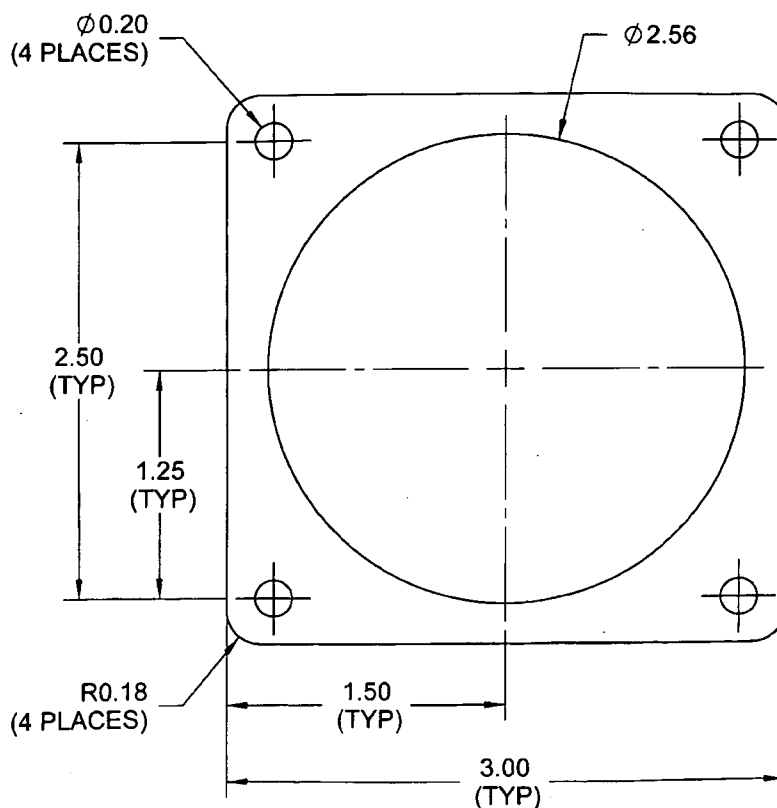




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DATE 08.12.19		TITLE EYEBALL ADAPTER	SCALE 1:1

RELEASED  
9/2/30 MP

w/o 53514



### D3480-7 GASKET

#### NOTES:

- 1) MATERIAL: RED (OR GRAY) 60 DUROMETER HI-TEMPERATURE SILICONE SHEET, 0.125" THICK (REF. DART SPEC. M-SIL60-.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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**SPOT WELD TEST RECORD**  
**AMS-W-6858A**  
CLASS 'C'

**TEST NO#:** 23

**EMPLOYEE:** Maui Gregory

**PART NUMBER:** D 3480-043

**JOB NUMBER:** 53514

**MATERIAL TYPE:** 304 L

**MATERIAL THICKNESS:** .018

**GROUP SPECIFICATION**

☐

Group 1: Aluminum & magnesium

☐

Group 2: Iron; nickel; cobalt

☒

Group 3: Titanium SS

**TEST RESULTS**

	PASS	FAIL	
VISUAL:	[ / ]	[   ]	
PENETRATION:	[ / ]	[   ]	
PULL STRENGTH:	[ / ]	[   ]	PSI Reading: _____

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

**DATE OF TEST COUPON:** 10/10/09

**QUALIFIER:** SB